



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

*split
(5)*

D2933-1BL
Job Sheet 167805



Part No: D2933-1BL

Job Qty: 10 ea

Part Name: Saddle LH In, 206



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/7/17

Job Tracking No:

Due Date: 11/24/17

Created By: Victoria Michaud-Febrille

Type: SOLD

Description:

Ship Via:

Rev C.

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/23/17	11/23/17	0.00	0.00	Start Up Machining		<i>FK 17-12-4</i>
100	CNC Vertical Machining	10 pcs	11/23/17	11/23/17	0.24	8.58	HAAS 1		<i>SBL 17/12/06</i>
110	Mill Conv	10 pcs	11/23/17	11/23/17	0.00	8.57	Mill Conv 1		<i>SBL 17/12/06</i>
120	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC1		<i>SBL 17/12/06</i>
130	QC	10 pcs	11/23/17	11/23/17	0.00	0.00	QC8		<i>M.A 14-12-11</i>
140	HandFinish	10 pcs	11/23/17	11/23/17	0.00	0.94	HandFinish1		<i>2017-12-12 JSL</i>
150	SprayPaint	10 pcs	11/24/17	11/24/17	0.00	0.55	Spray Paint	<i>Outsource</i>	<i>15-12-17</i>
160	QC	10 pcs	11/24/17	11/24/17	0.00	0.00	QC14		<i>11 JAN 17 2018</i>
170	Packaging	10 pcs	11/24/17	11/24/17	0.00	0.00	Packaging3	<i>57390</i>	<i>DEC 14 2017</i>
180	QC21-SA	10 Ea	11/24/17	11/24/17	0.00	0.00	QC21		<i>DEC 14 2017</i>

Part Op 100 - Program part number and batch number.

Descriptions: 110 - Machine Keyway and inspect per attached dimension sheet

150 - *** MASK ALL HOLES AS PER PAR16-484*** BATCH: _____

PRO: 38646 DAS 13 9-88

DEC 14 2017

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D6101-001	10	29	0	0

*5016627 x 7
5016623 x 3*

Part Specifications

Specifications could not be found.

Plex 11/7/17 8:20 AM dart.Michaud-Febrille.Victoria

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only

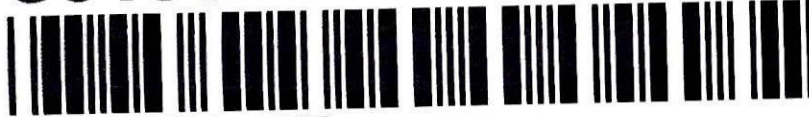
DISPOSITION

AGAINST DEPARTMENT/PROCESS

Work Order: _____	Describe _____
Part No. _____	
NCR No. _____	
Date: _____	

PART NO: D2933 – 1BL
Revision:
Operation: Outsource
Change No:

Mfg Date: 12/04/17
Job No: 167805



PART NO: D2933 – 1BL
Revision:
Operation: Start up Operation
Change No:

Mfg Date: 12/04/17
Job No: 167805

Dart Aerospace Ltd.
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Root Cause		No Re-	Opera	Offset	Suppli	Trainir	Use fo	Poor i	Rushir	Produ	Process improvement	Manufacturing Process	Past Due
Environment													
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre													
Material													
Internal Transport													
Tribal Knowledge													
LOA													
Substation													
Past Expiry Date													
Misidentified													

Marks/Chatter

misaligned/ott center

Turning Sequence

OTHER :

DART AEROSPACE LTD		Work Order:	167805
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.120	.121	.120	.120	.120
B	0.100	0.140		.122	.122	.119	.121	.119
C	0.100	0.140		.125	.125	.125	.125	.125
D	0.210	0.230		.222	.221	.221	.221	.221
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.511	.511	.511	.511	.511
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.257	.257	.257	.257	.257
L	0.312	0.317		.312	.312	.312	.312	.312
M	0.235	0.240		.239	.238	.238	.238	.238
N	0.100	0.140		.123	.122	.122	.122	.121
O	0.540	0.560		.550	.550	.550	.550	.550
P	0.490	0.510		.500	.500	.500	.500	.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.490	2.494	2.492	2.494	2.494
S	0.240	0.270		.252	.252	.252	.252	.252
T	0.100	0.180		.140	.133	.140	.138	.138
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.125	1.145		1.134	1.135	1.135	1.136	1.136
Y	1.565	1.585		1.575	1.575	1.575	1.575	1.575
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
AE								

Accept/Reject

Measured by: SBL / J.P.	Date: 17/12/06
Audited by: B-a	Date: 17-12-11
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

DART AEROSPACE LTD	Work Order:	167805
Description: 206 Saddle, Inboard, Left side	Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				¹ 5	² 7	³ 8	⁴ 9	⁵ 10
A	0.100	0.140		.120	.120	.121	.121	.121
B	0.100	0.140		.120	.122	.120	.120	.121
C	0.100	0.140		.125	.125	.125	.126	.125
D	0.210	0.230		.221	.222	.221	.221	.221
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.500	2.500	2.500	2.500	2.500
H	0.510	0.515		.511	.511	.511	.511	.511
I	1.572	1.582		1.577	1.577	1.577	1.577	1.577
J	2.495	2.505		2.500	2.500	2.500	2.500	2.500
K	0.257	0.262		.257	.257	.257	.257	.257
L	0.312	0.317		.312	.312	.312	.312	.312
M	0.235	0.240		.238	.238	.238	.238	.238
N	0.100	0.140		.121	.122	.120	.121	.121
O	0.540	0.560		.550	.550	.550	.550	.550
P	0.490	0.510		.500	.500	.500	.500	.500
Q	3.715	3.725		3.720	3.720	3.720	3.720	3.720
R	2.470	2.510		2.493	2.492	2.490	2.494	2.493
S	0.240	0.270		.251	.251	.251	.251	.251
T	0.100	0.180		.138	.140	.140	.140	.138
U	1.625	1.635		1.630	1.630	1.630	1.630	1.630
V	1.362	1.372		1.367	1.367	1.367	1.367	1.367
W	0.316	0.321		.316	.316	.316	.316	.316
X	1.125	1.145		1.135	1.135	1.135	1.135	1.135
Y	1.565	1.585		1.575	1.575	1.577	1.575	1.575
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								
AE								

Accept/Reject

Measured by: <i>Blasien Ladurikse</i>	Date: 17/12/06
Audited by: <i>B.F.</i>	Date: 17-12-11
Prototype Approval: N/A	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	

DART AEROSPACE LTD		Work Order:	1167805
Description: 206 Saddle, Inboard, Left side		Part Number:	D2933-1
Inspection Dwg: D2933 Rev: C DSK: Rev:		Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ **First Article**
☐ **Prototype**

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
A	0.100	0.140						
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E	1.245	1.255						
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G	2.495	2.505						
H	0.510	0.515						
I	1.572	1.582						
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P	0.490	0.510						
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R	2.470	2.510						
S	0.240	0.270						
T	0.100	0.180						
U	1.625	1.635						
V	1.362	1.372						
W	0.316	0.321						
X	1.125	1.145						
Y	1.565	1.585						
Z	0.178	0.198						
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AB								
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AD								
AE								
Accept/Reject								

Measured by:		Date:	
Audited by:		Date:	
Prototype Approval:	N/A	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	06.10.03	Removed DT8683, DT8686 & DT8690	KJ/JLM	
D	07.03.21	Revised per drawing revision C	KJ/JLM	
E	08.01.16	DT8695 A/B removed from dimension Y	KJ/EC/DD	



Dart Aerospace Ltd.
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Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038646

Supplier: ATE003-VC
Atelier Debosselage
358 Principale
Calumet
QC
J0V 1B0 Canada
Phone: 819 242 5633

PO No: PO038646
PO Date: 12/14/17
Due Date: 12/15/17
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	167807	D2938-1BL	Saddle LH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
2	167808	D2938-2BL	Saddle RH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
3	167804	D2932-2BL	Saddle RH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** SPRAY PAINT BLEU	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
4	167806	D2933-2BL	Saddle RH In, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
5	167811	D2939-2BL	Saddle RH In, 206 ** MASK ALL HOLES AS PER PAR16-484***	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
6	167803	D2932-1BL	Saddle LH Out, 206 ***MASK ALL HOLES AS PER PAR16-484*** BATCH: _____	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
7	167805	D2933-1BL	Saddle LH In, 206 *** MASK ALL HOLES AS PER PAR16-484*** BATCH: _____ ISSUE PO _____	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
8	167810	D2939-1BL	Saddle LH In, 206 ***MASK ALL HOLES AS PER PAR16-484*** ISSUE PO	Firmed	12/15/17	5 pcs	0 pcs	5 pcs	\$25.00/pcs	\$125.00
9	168325-A	D206-667-107BL	Fwd Crosstube - Mid Height 206L / L1 / L3 / L4, Blue	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00



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PURCHASE ORDER PO038646

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
			ISSUE PO _____ *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** **VERIFY BY _____ BATCH # TO MATCH W/O _____ ***VERIFY BY _____ PART # TO MATCH W/O _____ ***MASK SCRIBE B# & P# AND VERIFY*** 1-Prime inside and outside crosstube as per QSI 005 4.2 2-Paint outside crosstube as per QSI 005 4.2 PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____							
10	167820-L	D206-642-341BL	Replacement Skidtube (Fits LH or RH) ISSUE PO _____ ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484*** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
11	167820-K	D206-642-341BL	Replacement Skidtube (Fits LH or RH) ISSUE PO _____ ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484*** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start Time: _____ Fininsh Time: _____ PAINT:DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____	Firmed	12/15/17	1 pcs	0 pcs	1 pcs	\$225.00/pcs	\$225.00
Grand Total:										\$1,675.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.